

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002166**Date Inspected:** 10-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Fu Guo Gang	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower/OBG	

Summary of Items Observed:

Ultrasonic testing of Deck Panels and Side/Bottom plates

This QA inspector arrived at ZPMC for continued observation of the Self-Anchored Suspension Tower (SAS) and Orthotropic Bridge Girders (OBG). While performing the periodic observations in the tower assembly shop bay 1 and 2 it was observed that ZPMC was performing Ultrasonic Testing (UT) on tower skin plates with component numbers as follows; SSD1-SA15 A/F weld 13A was acceptable from ZPMC UT technicians and SSD1-SA15 A/F weld 26A was rejectable. This information was relayed to this QA inspector from ZPMC QC/CWI Fu Guo Gang and the UT technicians Eshung Qin. Both weldments were repairs from previous UT examinations performed by ZPMC (R1). For both welds it is noted that only half of the plate weld has been tested due to double V weld joint ZPMC will rotate the diaphragm plates 180° over to test the other side of the weldments weld numbers 13B and 26B. This should be done on the AM shift due to the time of completion for the UT testing was at the end of their shift.

This QA inspector proceeded with the UT verification of several weldments in bays 1 and 4 for deck panel rib splices and bottom plate WT stiffener splices. The weld numbers are as follows; DP053-001-014, DP300-001-118 through 120, DP275-001-118 through 120 and BP021-001-37, 38, 43 and 44. During the UT verification no rejectable indications were noted as per AWS D1.5. A UT report 6027 will be generated for these locations.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Hager, Craig	QA Reviewer
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